

Work Order ID 130887

130887

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March-26-15 1:27:01 PM

Item ID: D2344 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Deck Plate Aft
 Start Date: 3/26/15 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 15-03-26 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2344	Rev F								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per dwg prog rev: <u>F</u> dwg rev: <u>F</u>								
	2-deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

⑥

02/15/03/27

⑥

02/15/03/27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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MAR 30 2015

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Revision ID:			Stop	*NS2*
Item Name: Deck Plate Aft				
Start Date: 3/26/15	Start Qty: 6.00	*6*	Cust Item ID:	
Required Date: 3/26/15	Req'd Qty: 6.00	*6*	Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
155	QC7-Inspect Chemical Conversion Coat	0.00							
155									
QC	Memo	0.00							
Quality Control									
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating									
	START TIME: 11:30								
	FINISH TIME: 12:00								

DQA: _____ Date: _____



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Transport									
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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Item ID: D2344 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Deck Plate Aft
Start Date: 3/26/15 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/26/15 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170	QC3- Inspect Part Finish	0.00							38 9-89
-----	--------------------------	------	--	--	--	--	--	--	-------------------

170

QC

Memo

0.00

Quality Control

APR 07 2015

180	Identify as per dwg & Stock Location: <u>SL 225A</u>	0.00							
-----	--	------	--	--	--	--	--	--	--

180

Packaging

Memo

0.00

Packaging

DAS
27
9-89

APR 09 2015

190	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

190

QC

Memo

0.00

Quality Control

MLJ 1504-09DIS-4-9

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Picklist Print

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Page 1

Work Order ID: 130887

130887

Parent Item: D2344

D2344

Parent Item Name: Deck Plate Aft

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:D00.06.26Removed P/O for powder coatEC

IPP Rev:E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

100

sf

239.7669

0.745

5

M2024T3S 063

2024-T3 .063 sheet

015/03/27

Location

Loc Qty

Loc Code

MAT022

239.7669

m127866

16

m130000

0.0989

m130525

223.668

5

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DART AEROSPACE LTD		Work Order: 130887
Description: Litter Deck Plate Kit (350)		Part Number: D2344
Inspection Dwg: D2344	Rev: F	Page 1 of 1

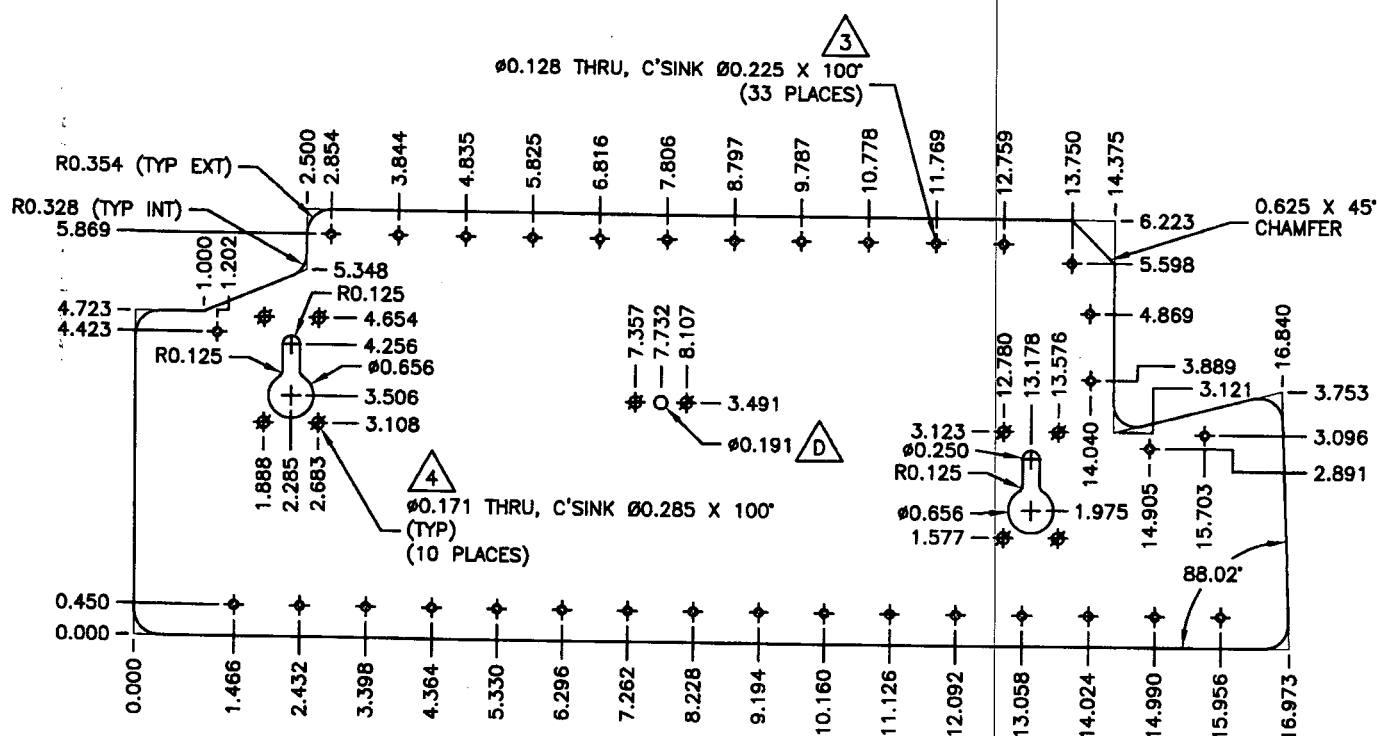
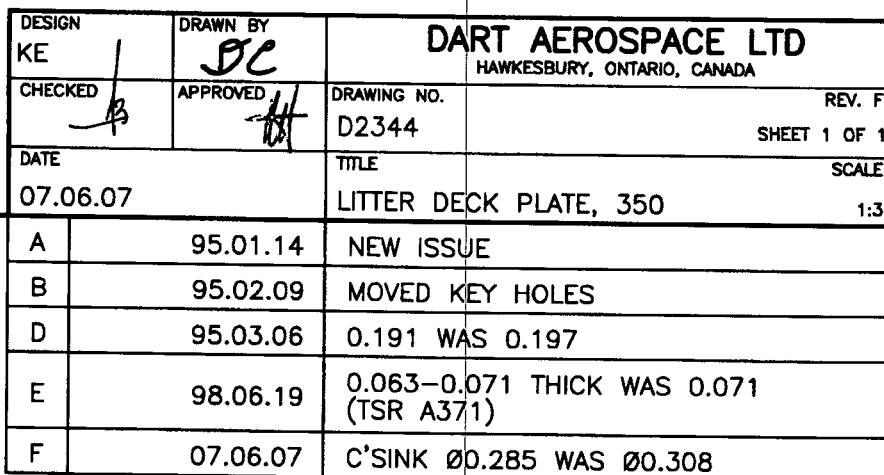
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.227	/		V-D-02	
5.598	+/-0.010	5.595	/		Tap	
4.869	+/-0.010	4.869	/		V-D-01	
3.889	+/-0.010	3.890	/			
3.096	+/-0.010	3.095	/			
2.891	+/-0.010	2.890	/			
16.973	+/-0.010	16.975	/			
0.450	+/-0.010	.451	/			
4.423	+/-0.010	4.425	/			
4.723	+/-0.010	4.725	/			
1.202	+/-0.010	1.203	/			
5.869	+/-0.010	5.870	/			
4.654	+/-0.010	4.655	/			
Ø0.656	+0.005/-0.000	Ø.655	/			
1.888	+/-0.010	1.890	/			
2.285	+/-0.010	2.287	/			
2.683	+/-0.010	2.685	/			
Ø0.171	+0.005/-0.000	Ø.170	/			
3.491	+/-0.010	3.494	/			
Ø0.191	+0.005/-0.000	Ø.190	/			
3.123	+/-0.010	3.125	/			
1.975	+/-0.010	1.980	/			
Ø0.128	+0.005/-0.001	Ø.127	/			

Measured by: DA	Audited by: 38	Prototype Approval:	N/A
Date: 15/03/27	Date: MAR 27 2027	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	BE



- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/4
(REF. DART SPEC. M2024T3S)
- 2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) COUNTERSINK HOLES MARKED ϕ TO $\phi 0.225 \times 100^\circ$
- 4) COUNTERSINK HOLES MARKED ϕ TO $\phi 0.285 \times 100^\circ$
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

 $\triangle F$

RELEASED

07.06.22

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